

# Work Order ID 110480

Friday, December 20, 2013 9:16:37 AM

**\*110480\***

Rev # 5-13/12/24  
~~PRELIMINARY ISSUE~~ Page 1

Item ID: D5032-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: PRELIM Stop **\*NS2\***  
 Item Name: Doubler  
 Start Date: 12/20/2013 Start Qty: 16.00 **\*16\*** Cust Item ID:  
 Required Date: 12/27/2013 Req'd Qty: 16.00 **\*16\*** Customer:  
 Reference:

Approvals: Process Plan: MF Date: 12-12-20 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5032	<u>PAI</u> <u>Rev A</u>	<u>DAS</u> 27 9-89 <u>DAS</u> 10 9-89							

110

0.00

**\*110\***

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: PAI

Prog Rev: PAI

2-Deburr if necessary

16 EL 13-12-20

120

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*120\***

QC

Memo

0.00

Quality Control

16 EL 13-12-20

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Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00 13/12/20				16			Inspect as per Dwg PA1
140 <b>*140*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00				16		76/13-12-20	
150 <b>*150*</b> QC Quality Control	QC7-Inspect Chemical Conversion Coat  Memo	0.00 0.00 13/12/20				16			Inspect as per Dwg PA1

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Item ID: D5032-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
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Start Date: 12/20/2013 Start Qty: 16.00 **\*16\*** Cust Item ID:  
Required Date: 12/27/2013 Req'd Qty: 16.00 **\*16\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location:								
<b>*160*</b>									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									

*used on 12/16  
D135-816-0110  
B110515*

*12/18/20*

DAS  
27  
9-89

*mcj 14-01-24*  
Release Dwg Rev A  
POSITIVE RECALL  
EFFECTIVE 13-12-20 AUTH *me*  
RELEASED 8 DATE 13/12/24 13-12-20

# Picklist Print

Friday, December 20, 2013 9:16:36 AM

Page 1

Work Order ID: 110480

Parent Item: D5032-3

Parent Item Name: Doubler

Start Date: 12/20/2013

Required Date: 12/27/2013

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP REV:A NEW ISSUE 13.12.20 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.040

Purchased

No

sf

257.0000

6061-T6 .040 Sheet

3

EL 13-12-20

Location

Loc Qty

Loc Code

MAT021

257

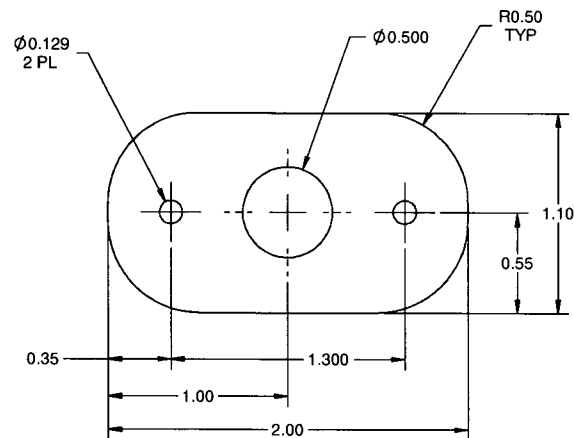
m126350

96

m126981

161

0.4



**D5032-3 DOUBLER**

**PRELIMINARY ISSUE**

**13.12.09**

**NOTES:**

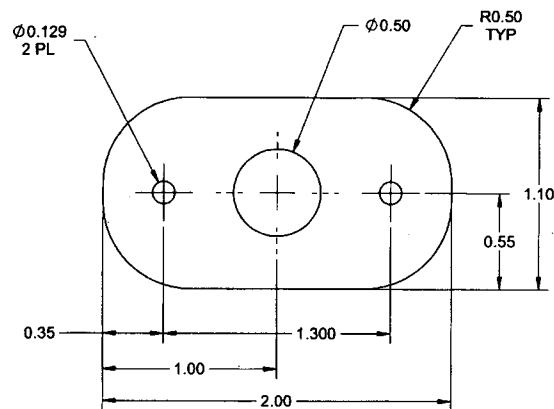
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>DL</i>	DRAWING NO. <b>D5032</b>	REV. PA1
MFG. APPR.		SHEET 2 OF 2	
APPROVED		TITLE	SCALE
DE APPR.		<b>DOUBLER</b>	NTS
DATE	<b>13.12.09</b>	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

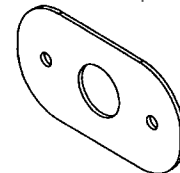
*ME*  
*13-12-20*  
*#110480*







**D5032-3 DOUBLER**



**NOTES:**

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- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

RELEASED  
2013-12-23  
125

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	DS	D5032	SHEET 2 OF 2
APPROVED	SL	TITLE	SCALE
DE APPR.		DOUBLER	NTS
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